

# Work Order ID 52853

October 15, 2009 2:45:58 PM



Page 1

Item ID: D3805-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Plate

Start Date: 15/10/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 27/10/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: PL

Date: 09-10-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3805

Rev A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3805

Dwg Rev: 9

Prog Rev: 1

2-Deburr if necessary

RB 9-10-20

(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

RB 9-10-20

# Work Order ID 52853

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Page 2

Item ID: D3805-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Plate

Start Date: 15/10/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 27/10/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

QC8- Inspect parts - second check

0.00



27 Oct 10/20

QC

Memo

0.00

Quality Control

12

8

130

0.00



Brake NC

Memo

0.00

28 Oct 10/22

Brake NC

Form as per Dwg D3805 using Jigs DT8261 and DT8326

12

8

140

QC5- Inspect part completeness to step on W/O

0.00



27 Oct 10/22

QC

Memo

0.00

Quality Control

12

8

**Work Order ID 52853**

October 15, 2009 2:45:58 PM



Page 3

Item ID: D3805-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Plate

Start Date: 15/10/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 27/10/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location: W/A

0.00



Packaging

Memo

0.00

Packaging

EL 9-10-28 (A12)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/3078  
MF 09-10-29

# Picklist Print

October 15, 2009 2:46:03 PM

Page 1

Work Order ID: 52853



Parent Item: D3805-3RevA



Parent Item Name: Plate



Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S18GA 		Purchased	No			100	sf	242.1552	20.0463 			
304/316 .050 Sheet												

B 9-10-20

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	242.1552053	
108156	0.98526316	
111743	23.7174	
112178	89.4525421	
112885	128	

112178



8

7

6

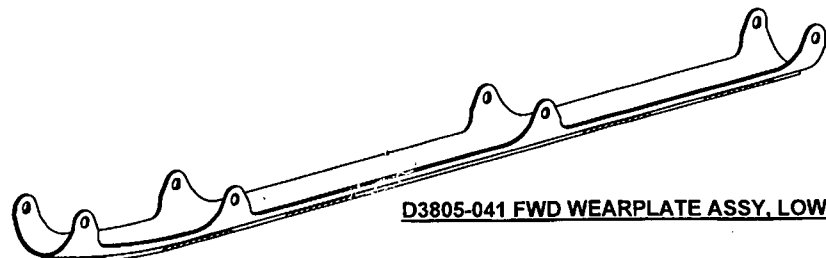
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4

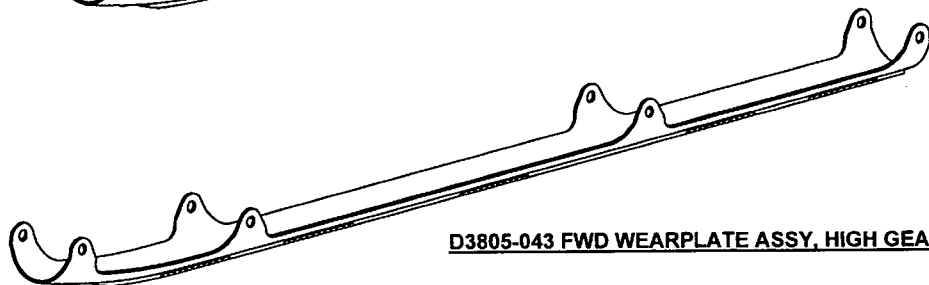
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2

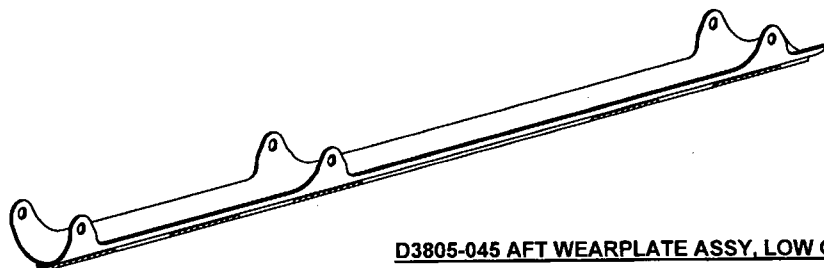
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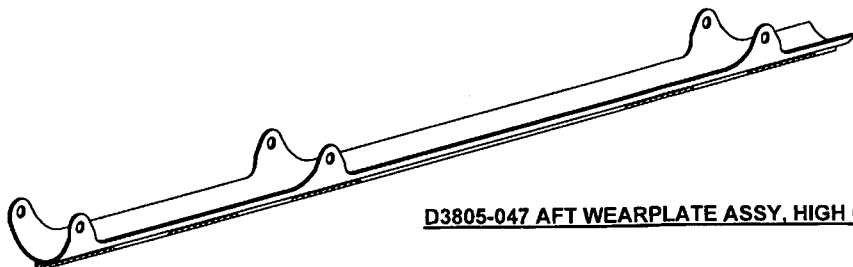
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

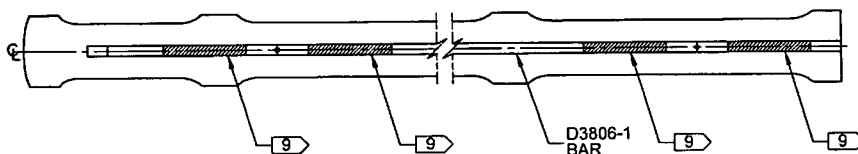
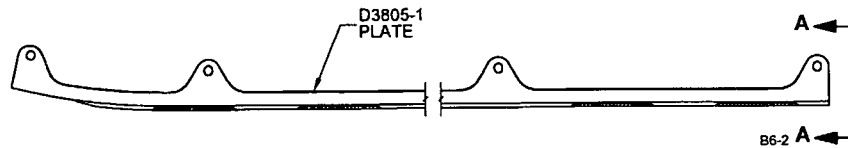
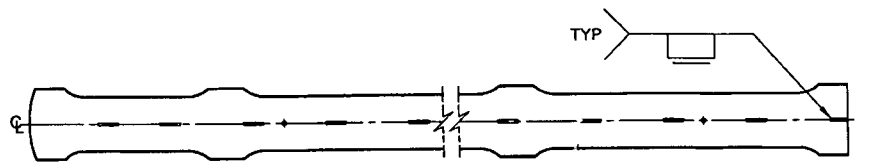
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1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

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NO. 52853

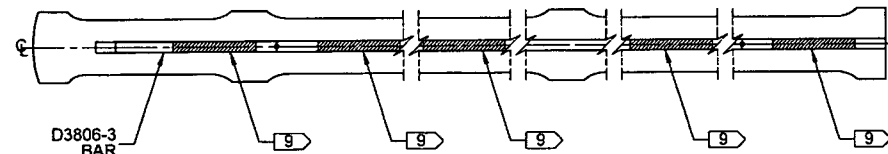
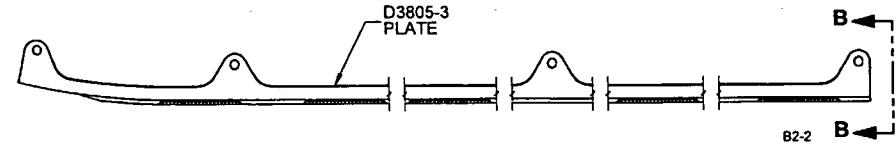
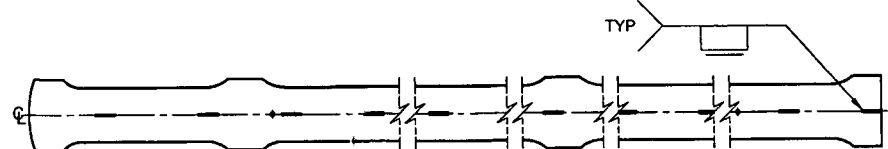
*BA 09-10-15*

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*49 09-03-03*  
Per ECN 09-538

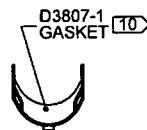
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REV.	DESCRIPTION	BY	DATE
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CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D3805	SHEET 1 OF 8
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	WEARPLATE ASSY	NTS
DATE	08.11.21	<small>COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



**D3805-041 FWD WEARPLATE ASSY, LOW GEAR**

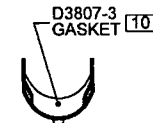


**D3805-043 FWD WEARPLATE ASSY, HIGH GEAR**



**VIEW A-A** C5-2

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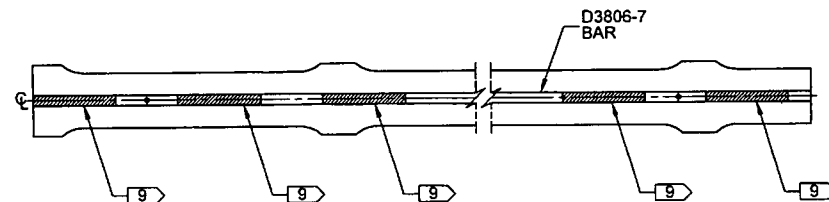
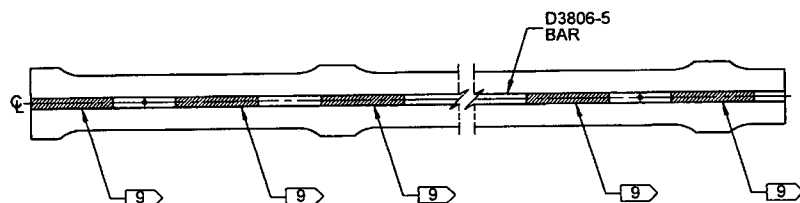
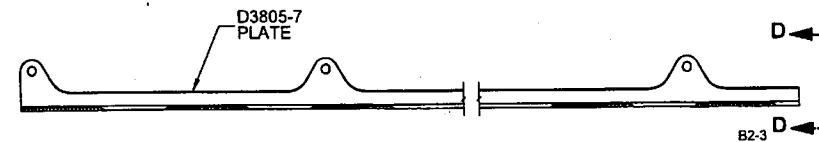
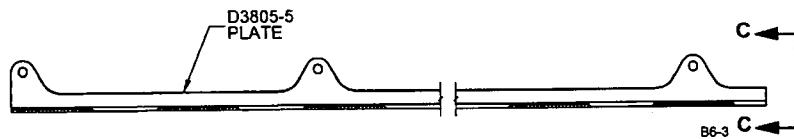
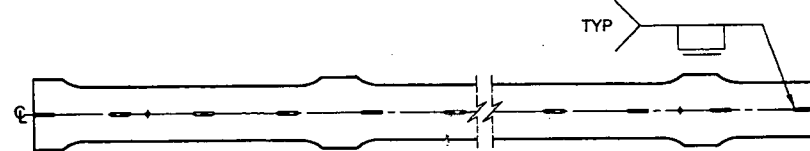
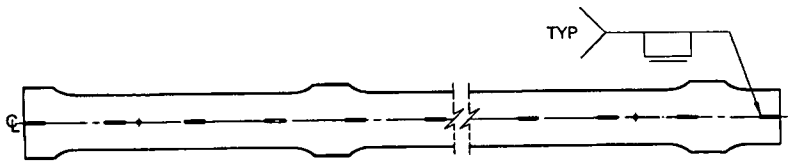


**VIEW B-B** C1-2

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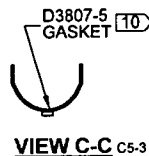
- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: D3805-041 = 3.79 lbs; D3805-043 = 4.36 lbs
  - 8) WELDING: PER QSI 004
  - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
  - 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN	10	<b>DART AEROSPACE USA, INC.</b>	
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MFG. APPR.	10	D3805	SHEET 2 OF 8
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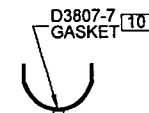


**D3805-045 AFT WEARPLATE ASSY.**

**D3805-047 AFT WEARPLATE ASSY.**



**VIEW C-C C5-3**



**VIEW D-D C1-3**

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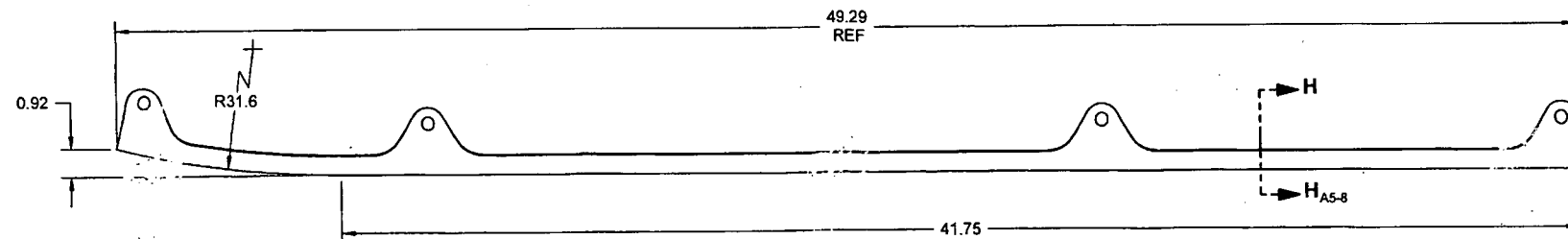
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  - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: D3805-045 = 3.93 lbs; D3805-047 = 4.21 lbs
  - 8) WELDING: PER QSI 004
  - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
  - 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

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MFG. APPR.	197	D3805	SHEET 3 OF 8
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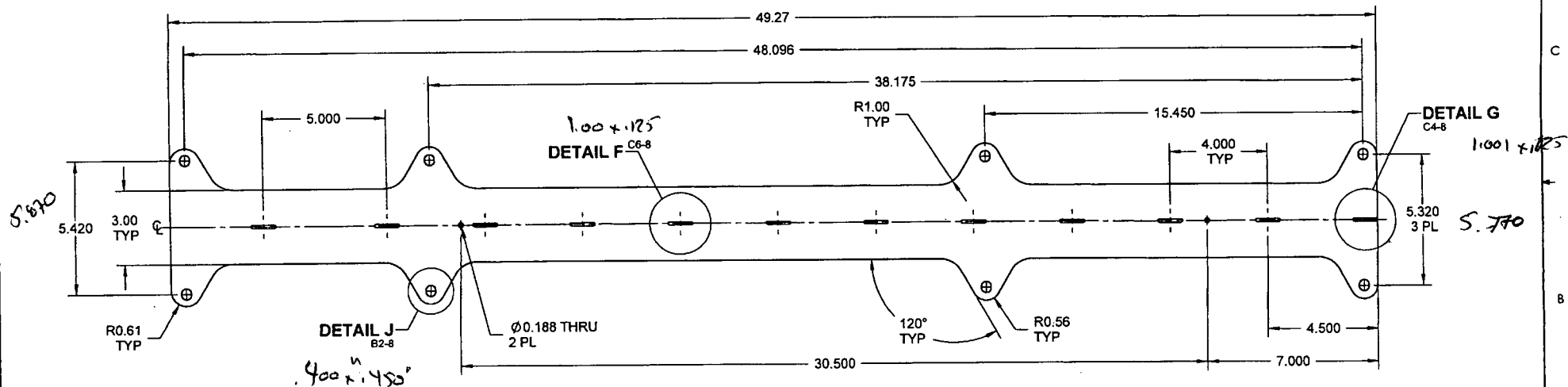




8 7 6 5 4 3 2 1



**D3805-3 PLATE**  
(MAKE FROM D3805-3F)



**D3805-3F PLATE**

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**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.37 lbs

DESIGN	140	<b>DART AEROSPACE USA, INC.</b>	
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MFG. APPR.	140	D3805	SHEET 5 OF 8
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DE APPR.	140	WEARPLATE ASSY	NTS
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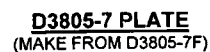


RELEASE  
49 04 03 03

2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 2.06 lbs

DESIGN	<i>JP</i>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA  DRAWING NO. <b>D3805</b>  TITLE <b>WEARPLATE ASSY</b>  COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	REV. A
DRAWN	<i>A</i>		SHEET 6 OF 8
CHECKED	<i>ASS</i>		SCALE
MFG. APPR.	<i>AS</i>		NTS
APPROVED	<i>JP</i>		
DE APPR.	<i>JP</i>		
DATE	08.11.21		

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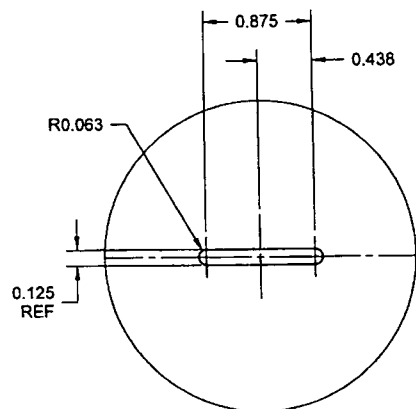


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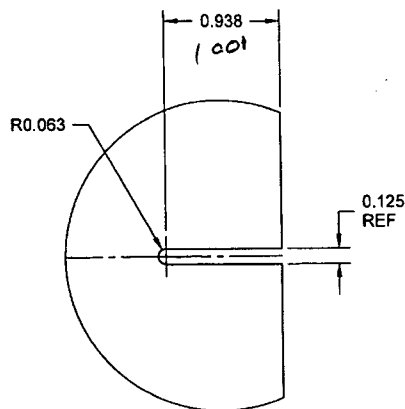
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3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 2.13 lbs

SHORE  
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SUBJECT  
WITH  
WON  
NO. 52853

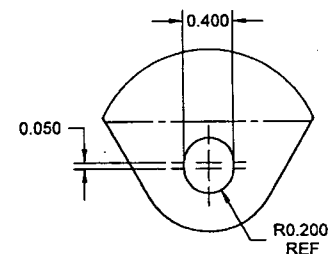
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DRAWN	J	PORT HADLOCK, WA	
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	D	D3805	SHEET 7 OF 7
APPROVED	VP	TITLE	SCALE
DE APPR.	J	<b>WEARPLATE ASSY</b>	NTS
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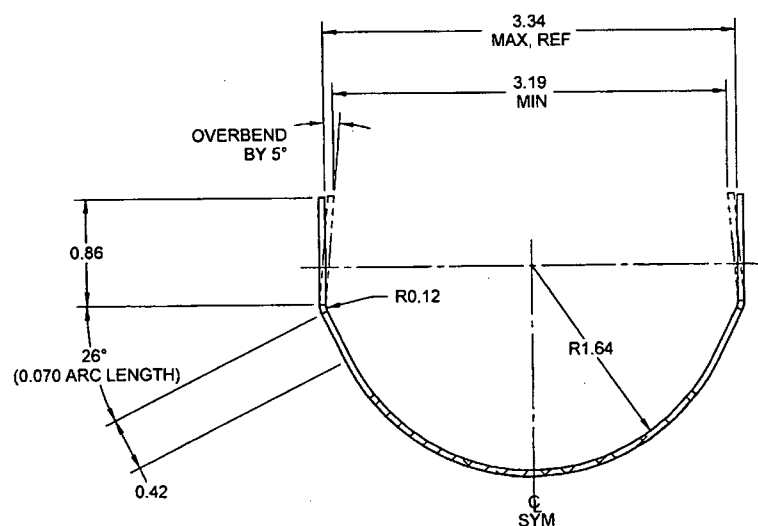
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SLOT DETAIL TYP  
SCALE 4X  
C5-4  
C5-5  
C4-6  
C4-7



**DETAIL G**  
SLOT DETAIL TYP  
SCALE 4X  
C1-4  
C1-5  
C1-6  
C2-7



**DETAIL J**  
SCALE 4X  
B6-4  
B7-5  
B6-6  
B5-7



**SECTION H-H**  
SCALE 4X  
D3-4  
D3-5  
D3-6  
D3-7

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WORK CENTER  
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CHECKED	155	DRAWING NO.	REV. A
MFG. APPR.	197	D3805	SHEET 8 OF 8
APPROVED	197	TITLE	SCALE
DE APPR.	197	<b>WEARPLATE ASSY</b>	NTS
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